

Work Order ID 83348

April-17-12 2:18:28 PM

83348

Page 1

Item ID: D3290-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Window

Stop

NS2

Start Date: 17/04/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 01/05/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/12 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3290	Rev C					9			
100		0.00							
100	FLOW WATER JET								
Waterjet	Memo	0.00							B12-4-07
FLOW CNC Waterjet	1-Cut as per Dwg D3290 Dwg Rev: <u>C</u> Prog Rev: <u>C</u> 2-								
Poly Cast 1/8	Deburr if necessary								
110		0.00							
110	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							B12-4-07
Quality Control									
120		0.00							
120	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

89

08

12/05/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00

130

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Without removing protective skin remove sharp edge by degurring.

x9 *DL*
12/05/14

140

0.00

140

THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

1-THERMOFORM as per Drawing D3290 and Folio FTA001 Dwg.
Rev. C Folio Rev B 2-Engrave part# &
batch#, (D3290-3)

DL
12/05/14

150

0.00

150

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

DL
12/05/14

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8

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8

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

170

HAND FINISHING THERMOFORMING

0.00

Thermoform

Memo

0.00

Thermoforming Machine

Water sand and buff to remove scratches if required

DL
12/05/15

180

180

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Scratches

(+)

190

190

Identify as per dwg & Stock Location: *54*

0.00

Packaging

Memo

0.00

Packaging

Do not use on D3290-047 (9) SAO 12-08-13

W/O:		WORK ORDER CHANGES					
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Work Order ID 83348***83348***

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April-17-12 2:18:28 PM

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Accept

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Revision ID:

Item Name: Window

Stop ***NS2***

Start Date: 17/04/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 01/05/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

QC21- Final Inspection - Work Order Release

0.00

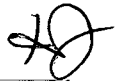
200

QC

Memo

0.00

Quality Control

12/06/14 
MLJ 12/06/13

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Picklist Print

April-17-12 2:18:33 PM

Page 1

Work Order ID: 83348

83348

Parent Item: D3290-3

D3290-3

Parent Item Name: Window

Start Date: 17/04/2012

Required Date: 01/05/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP A04.08.18New issueKJ/RF
 IPP B06.05.09Ecn 798 EC IPP Rev.
 C Removed QC8 Step 160 11/04/11 DL
 IPP C 07.05.29. Thermoform in-house DL
 IPP D 07.09.28 rev C dwg EC verified by: DD
 IPP E 07.11.28 Add --Hand finish deburring DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.125		Purchased	No			100	sf	114.2634	3	25.26316			

MACRI ICS 125

1/8" Polycast II Sheet

**

1312-4-07

Location

Loc Qty

Loc Code

MAT019

114.2634

110633

3

117324

0.2467

117431

10.7967

119591

100.22

119591

9

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

FWD
INBOARD

D2126-0780 LOCKING SEAL
(TRIM TO FIT)
D3290-1 WINDOW FRAME
D3290-3 WINDOW

1.10 (TYP)
DIST. FROM FRAME
EDGE TO WINDOW

D2126-0780 LOCKING SEAL
(REF)

ENSURE D3290-3 WINDOW IS INSTALLED
ON CORRECT SIDE OF D3290-1 WINDOW FRAME

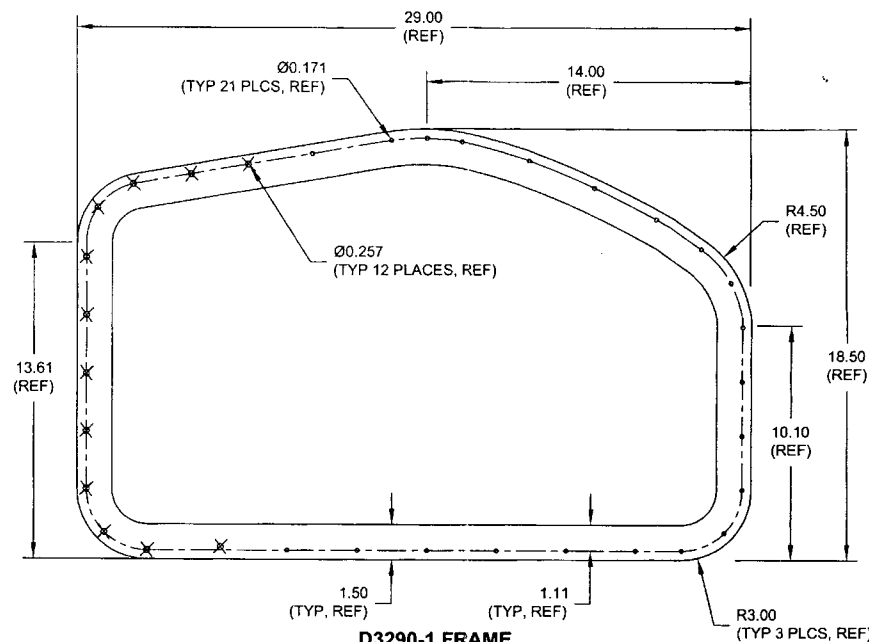
SECTION A-A
NTS

D3290-041 REPLACEMENT WINDOW ASSEMBLY

D3290-041 NOTES:
1) WEIGHT: 3.66 LBS

GENERAL NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED



D3290-1 FRAME

D3290-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
OR
5052-H32 ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
- 3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.47 LBS

RELEASED
07.07.24

DEO ATTACHED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 83348 MLJ

UNDER REVIEW

12/04/17

07.07.24

C	UPDATE DIMS PER PAR 188	DC	07.07.24
B	UPDATE MATERIAL PER NCR 029	MB	06.04.20
A	NEW ISSUE	RF	04.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3290
REV. C
SHEET 1 OF 2
TITLE
REPLACEMENT WINDOW ASSEMBLY
SCALE
1:5

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W/O:		WORK ORDER CHANGES					
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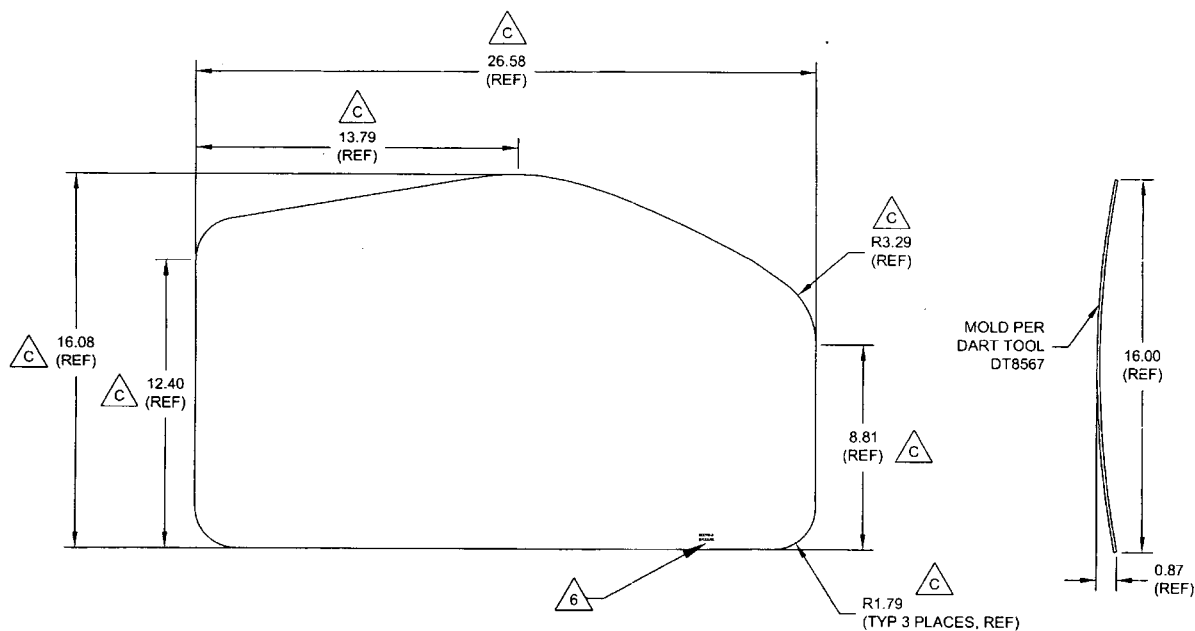
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83348



D3290-3 WINDOW

D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

W. J. 10/19
UNDER REVIEW
DEO ATTACHED
RELEASED
07.07.22

DESIGN	<i>WJ</i>	DART AEROSPACE LTD	
DRAWN	<i>WJ</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>WJ</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>WJ</i>	D3290	SHEET 2 OF 2
APPROVED	<i>WJ</i>	TITLE	SCALE
DE APPR.	<i>WJ</i>	REPLACEMENT WINDOW ASSEMBLY 1:1	
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>qp</i>	CHECKED <i>ls</i>	MFG. APPR. <i>E</i>	APPROVED <i>AD</i>		DE APPR. <i>#</i>		
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21		DATE 09/09/21		

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED
 2009-10-09
W

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833 18

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